



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

20NR-04-1
Job Sheet 173253



Part No: 20NR-04-1

Job Qty: 10 ea

Part Name: Solenoid



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/27/18

Job Tracking No:

Due Date: 3/30/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG 20NR-04 Rev 6 IPP Rev A 18.02.02 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		3/29/18	0.00	0.00	Start Up Machining-4		J.C.-L. 18-03-21
100	Mill Conv	10 pcs		3/30/18	0.50	2.00	Mill Conv 2		J.C.-L.
110	QC	10 pcs		3/30/18	0.00	0.00	QC2 Machining-5		J.C.-L.
120	QC	10 pcs		3/30/18	0.00	0.00	QC8 Machining-5		J.C.-L.
130	Packaging	10 pcs		3/30/18	0.00	0.00	Packaging3-2		MAR 2 2018
140	QC21-SA	10 Ea		3/30/18	0.00	0.00	QC21		GA143

Part Op 100 - 1-Drill hole in shaft. Shaft should be retracted when drilled. Studs facing you rotate shaft clockwise to the end of

Descriptions: stroke, push shaft into solenoid then drill as per DWG sheet 2 2-Engrave S/N and/or P/N number using Marktronic

engraver as per DWG. Jig drawer 185

130 - Identify and Stock

DAS

21

9-85

APR 06 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
H-1127-020P	TBD	10 pcs (1 ea)	90-Start up Operation	5024 453

H-2553-020

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	H-1127-020P	10	0	0

Part Specifications

Specifications could not be found.



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Email: sales@dartaero.com
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Plex 2/27/18 11:50 AM Dart.lajeunesse.marie

Container No: S053447



Part: 20NR-04-1

Job No: 173253

Serial No/Batch: S053447

Revision: 6

Inspector:

Date: 03/21/18

Michael Lee

From: Michael Lee
Sent: Saturday, February 10, 2018 1:57 PM
To: Jean-Luc Menard
Cc: Sylvie Boucher
Subject: C10-12 Solenoid

Hey JL,

I took a look at both solenoid drawings for the C10 and C45 hook.

I don't have any issues with drilling an additional hole on C10-12-0 Solenoid and installing the roll pin in order to use it with the C45 Hook.

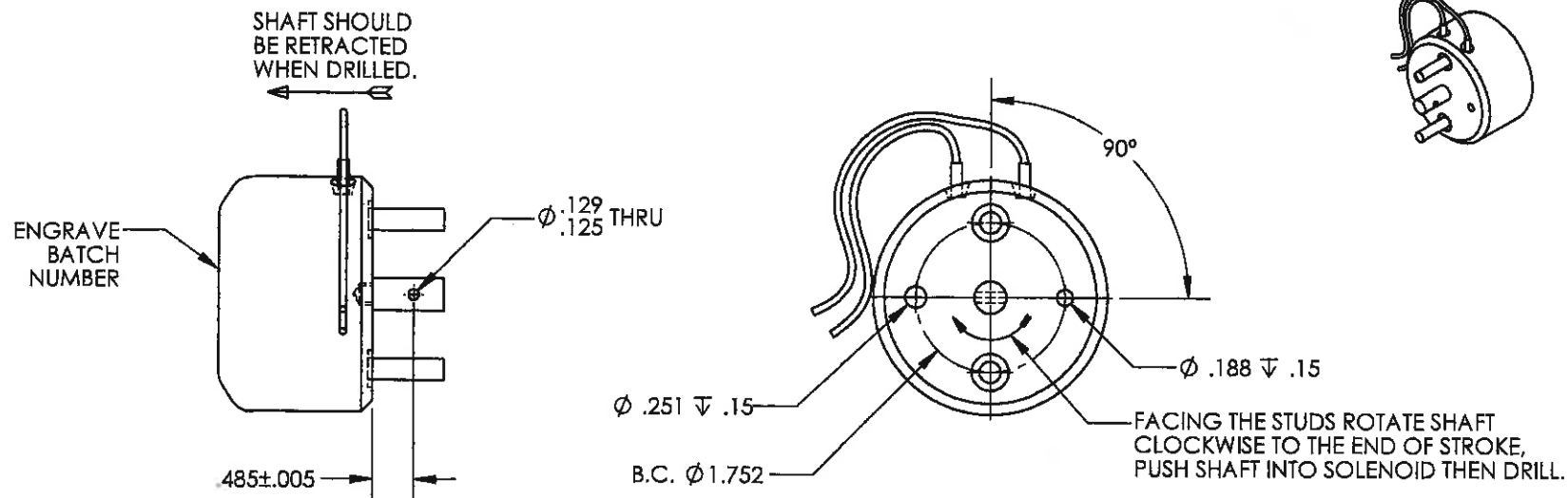
We should definitely get more of the H-2553-020 Solenoids on order.

Hope that helps.

Mike

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
6	14-0206	20NR-04-1 ADDED ENGRAVE BATCH # NOTE.	11/3/2014	DPD	JAG



20NR-04-1

SOLENOID

DART AEROSPACE	
TITLE SOLENOID	
DWG NO. 20NR-04-1	REV 6
MAT'L	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX $\pm .008$	HEAT
.XX $\pm .01$	TREAT
.X $\pm .1$	FINISH
ANGLES $\pm .5^\circ$	SPEC
1. BREAK ALL SHARP EDGES .016 x 45° OR .016R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 12/1/1995
SHEET 2 OF 3	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: 7/2Date: Oct 24/19Work Order update only ☐

Work Order: <u>173 253</u> Part No. <u>20NR-04-1</u> NCR No. <u>19-7564</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐									
Date: <u>08-03-21</u>	Step #: <u>100</u>	QTY Effective: <u>1</u> <u>9</u>		MRB (OSI042) Approval <u>MDA</u> <u>SCRAP</u>							
Description Work Order Deviation The hole 0.25-0.129 is supposed to be at 90° and it's at 77° (positioned wrong in Jig)			Disposition - QTY(1) 20NR-04-1 (H-2553-020) IS SCRAP.		03/23/18 Completed By <u>J.C.L.</u> <u>18-03-21</u> Lead hand / Supervisor Approval Verification <u>[Signature]</u> <u>18/03/21</u> QC / QA Coordinator Approval <u>D 18-3-23</u>						
Root Cause <table style="width:100%;"> <tr> <td style="width:50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☒ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>			Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☒ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	FAULT CATEGORY <table style="width:100%;"> <tr> <td style="width:33%;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:33%;"> Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:33%;"> Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> <td style="width:33%;"> ☒ Positioned Wrong Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>			Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	☒ Positioned Wrong Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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